

Work Order ID 74097

Wednesday, September 21, 2011 1:24:49 PM



Page 1

Item ID: D3914-041

Accept



Setup Start



Revision ID:

Item Name: Long Basket Lid Assembly (350)

Stop



Start Date: 9/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/30/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11/09/21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3914

B

100

Weld per dwg A/R S.S. rod Batch: 1114649 0.00



Large Fab

Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3914 using DT9607A
2- weld hinge (3) and Mounting brackets as per dwg D3914
inspect before welding mesh
3- tack weld mesh on basket as per dwg D3914
***make sure to place mesh correctly on lid, check with label plate before
tacking mesh***

[Signature]

PMB 11/09/27

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

[Signature] 11.09.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start

QC:

Date:

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Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control



8/10/13

D4030-041 / 137-1045

1 of 11 11/09/12

11/10/13
MF
11-09-30

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Picklist Print

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Page 1

Work Order ID: 74097

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 9/28/2011

Required Date: 9/30/2011


Start Qty: 1.00

Required Qty: 1.00


Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
as per dwg revB DD 10.08.18 verified by:EC

IPP Rev:B


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2581  Mounting Bracket		Manufactured	No			100	Each	34.0000	2	2		<i>PMB 11/09/27</i>	
--	--	--------------	----	--	--	-----	------	---------	---	---	--	---------------------	--

Location	Loc Qty	Loc Code
WA	34	
69258	1	
69739	2	
70766	2	
<u>73079</u>	29	

D3914-1  Rib		Manufactured	No			100	Each	7.0000	2	2		<i>PMB 11/09/27</i>	
---	--	--------------	----	--	--	-----	------	--------	---	---	--	---------------------	--

Location	Loc Qty	Loc Code
WA	3	
72087	1	
72656	2	
WA006	4	
<u>73629</u>	4	

D3914-7  Rib		Manufactured	No			100	Each	4.0000	2	2		<i>PMB 11/09/27</i>	
---	--	--------------	----	--	--	-----	------	--------	---	---	--	---------------------	--

Location	Loc Qty	Loc Code
WA	4	
<u>72794</u>	4	

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 74097

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 9/28/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

D4016-3 Manufactured No

100 Each

31.0000

3

3



Hinge Half, Lid



PMB 11/09/27

Location

Loc Qty

Loc Code

WA

30

72116

12

73630

18

WA005

1

71941

1

3

D4018-5 Manufactured No

100 Each

29.0000

9

9



Rib



PMB 11/09/27

Location

Loc Qty

Loc Code

WA

29

70758

5

72544

6

73631

18

9

D4020-5 Manufactured No

100 Each

4.0000

1

1



Mesh (350 Basket Long, Lid)



PMB 11/09/27

Location

Loc Qty

Loc Code

WA

4

68234

1

69162

1

73540

2

1

Wednesday, September 21, 2011 1:24:55 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Page 3

Work Order ID: 74097

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 9/28/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

D4021-3 Manufactured No

100 Each

11.0000

1

1



Data Plate



PMB 11/09/27

Location

Loc Qty

Loc Code

WA

11

71943

5

73632

6

D4035-041 Manufactured No

100 Each

3.0000

1

1



Lid Rib Assembly, Fwd (350 Basket)



PMB 11/09/27

Location

Loc Qty

Loc Code

WA

3

63720

0

72657

3

D4035-043 Manufactured No

100 Each

8.0000

1

1



Lid Rib Assembly, Aft (350 Basket)



PMB 11/09/27

Location

Loc Qty

Loc Code

WA

2

72542

2

WA006

6

73628

6

D2728-3 Manufactured No

140 Each

0.0000

1

1



Dart Logo label



X115050

11/09/29

Wednesday, September 21, 2011 1:24:55 PM

Shop Packet Print

Page 3

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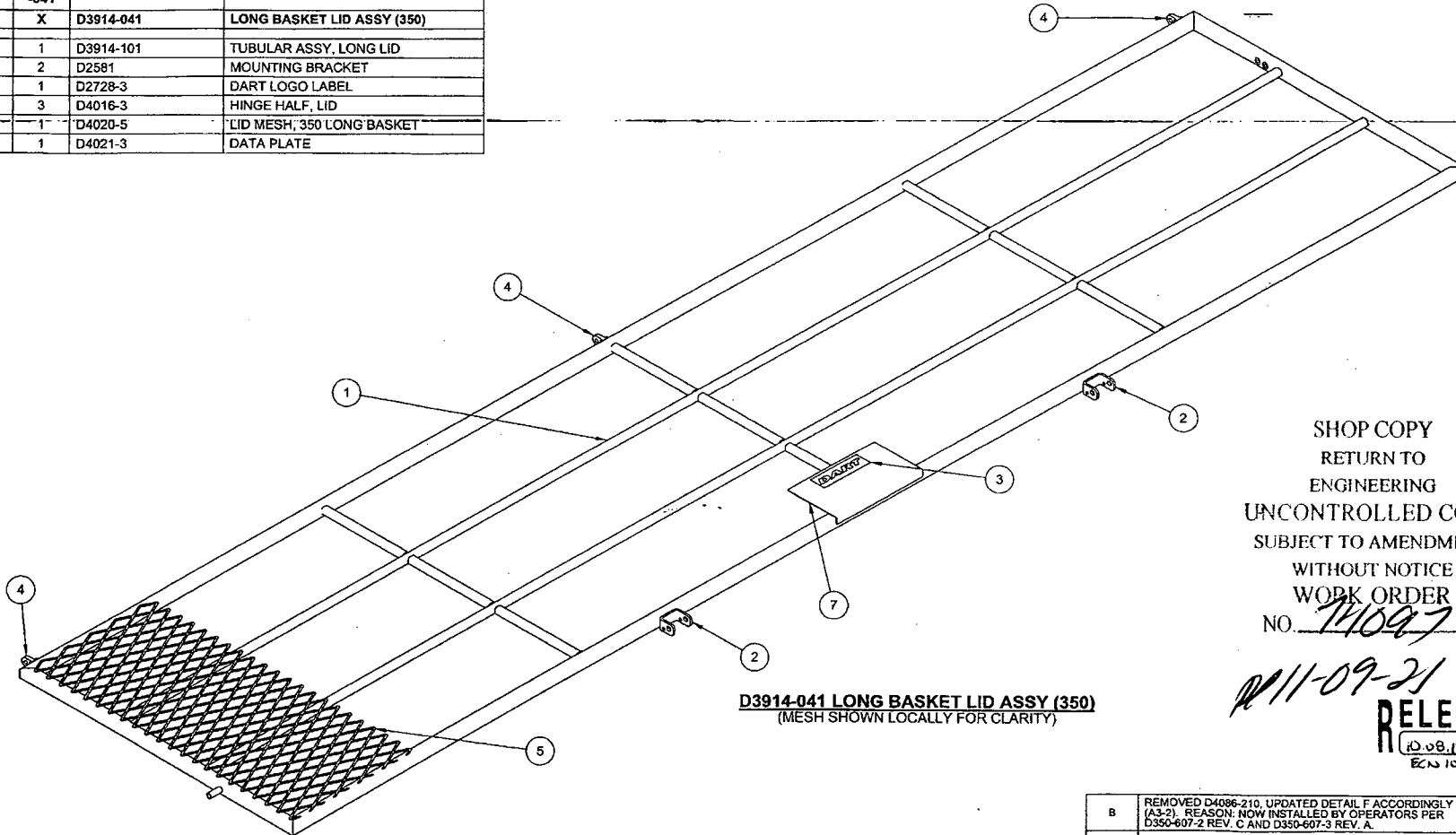
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ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74097

11-09-21

RELEASED
10-08-17 09
ECN 10-596

B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS		
DRAWN	SC		
CHECKED	SC		
MFG. APPR.	WJ		
APPROVED	WJ		
DE APPR.	WJ		
DATE	10.08.05		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3914** REV. B
SHEET 1 OF 4
TITLE **LONG BASKET LID ASSY (350)** SCALE NTS

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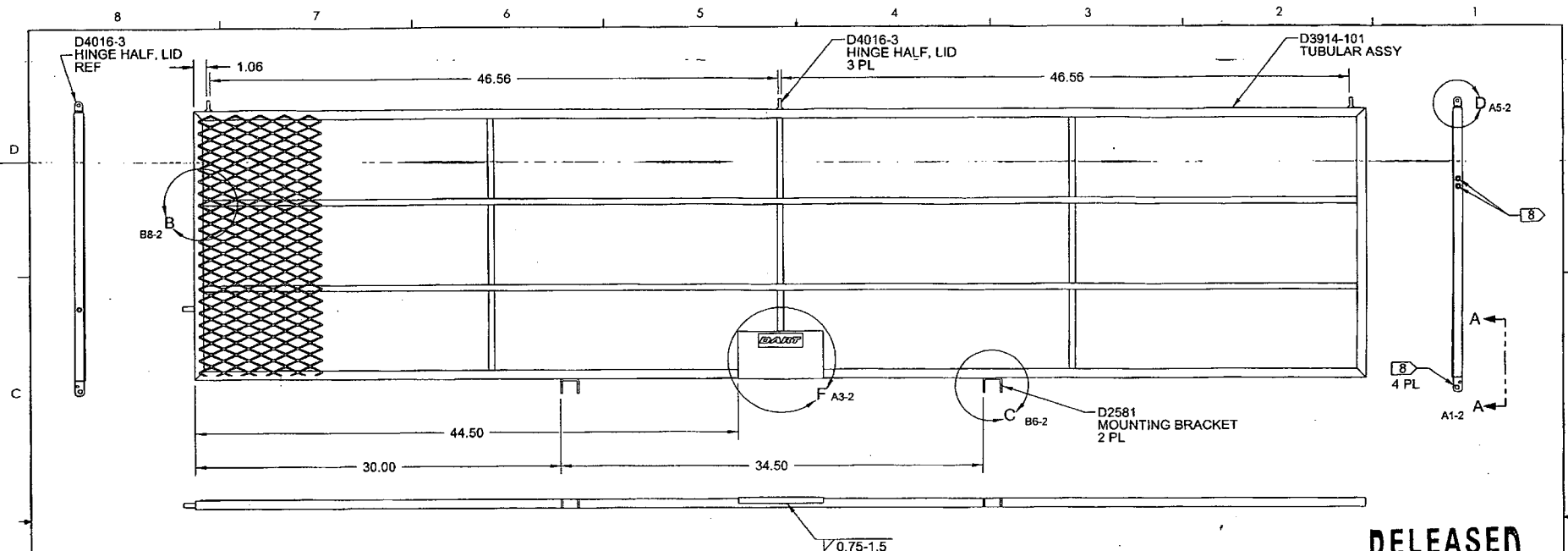
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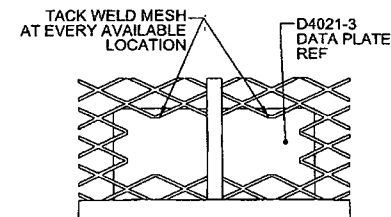
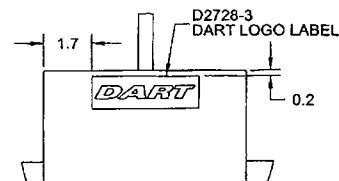
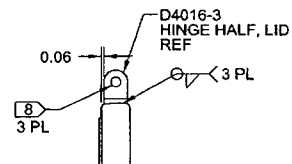
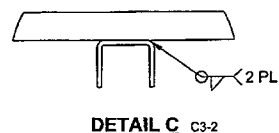
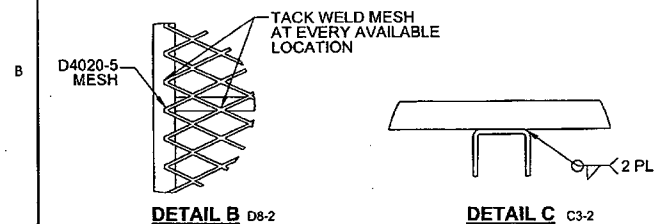
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NOTE: Date & initial all entries



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.12 CP



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

74097

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	SC	D3914	SHEET 2 OF 4
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	LONG BASKET LID ASSY (350)	
DATE	10.08.05	NTS	
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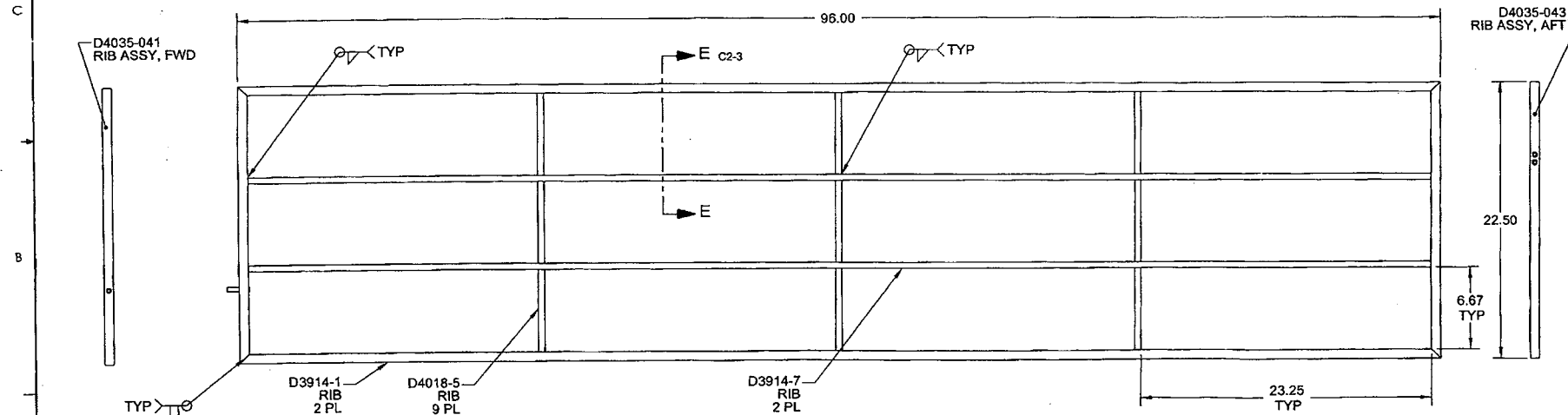
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3



RELEASED
10-08-05

8 D3914-101 TUBULAR ASSY, LONG LID

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 14.10 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
 - 9) WELD PER DART QSI 004

DESIGN	715	DART AEROSPACE LTD	
DRAWN	715	HAWKESBURY, ONTARIO, CANADA	
CHECKED	715	DRAWING NO.	REV. B
MFG. APPR.	715	D3914	SHEET 3 OF 4
APPROVED	715	TITLE	SCALE
DE APPR.	715	LONG BASKET LID ASSY (350) NTS	
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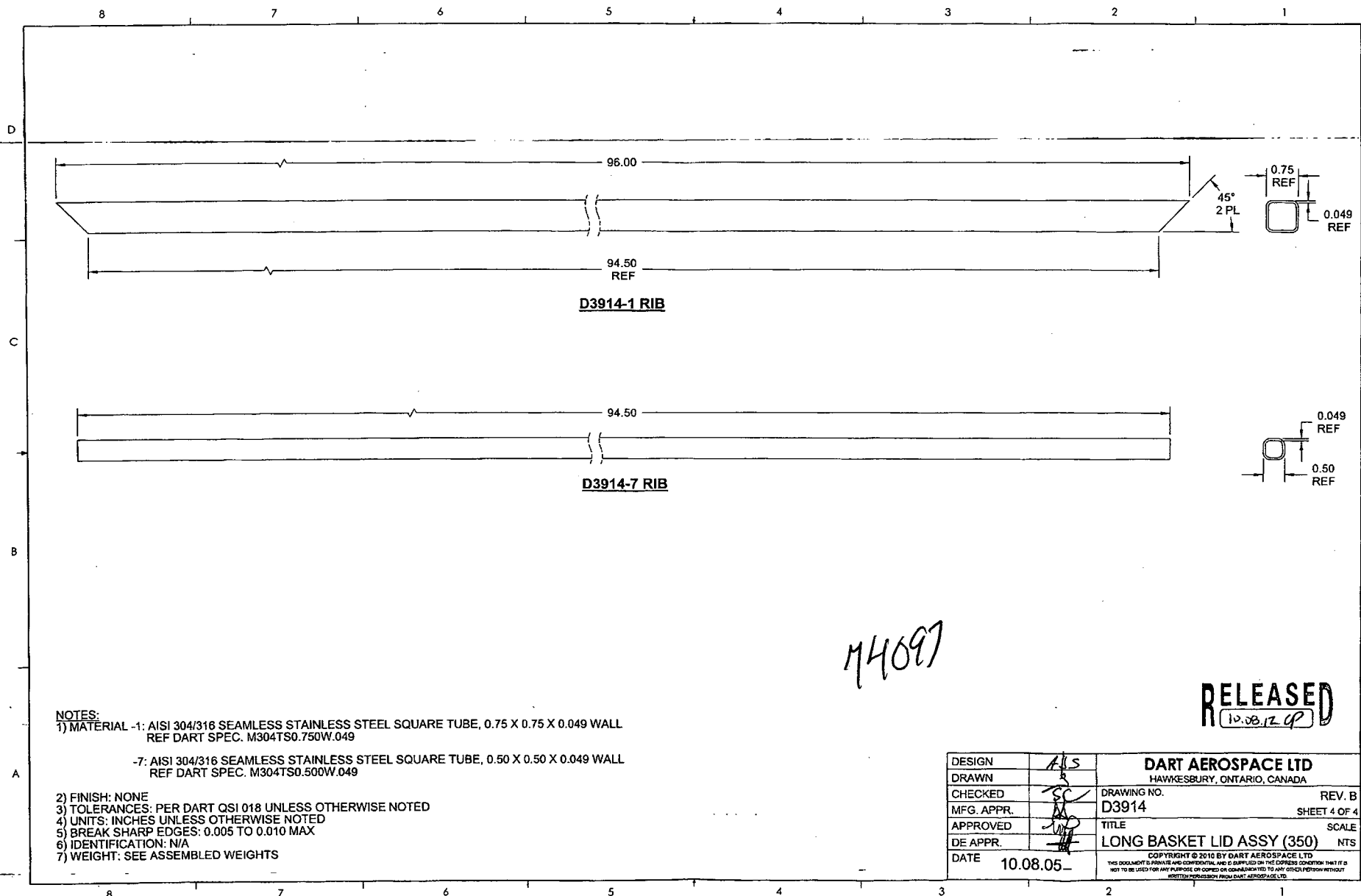
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NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED
10.08.12

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